

Date: Wednesday, 30/07/2008 5:28:04 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT FACING SEAT, LH		
Job Number	: 40809			Part Number	: D412769041		
Estimate Number	: 13462			Drawing Number	: IIN412-769 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 30/07/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 22/08/2008		
Previous Run	: 40808			Qty:	1	Um:	Each
Written By	:			Comment	: Est rev A 08-07-17 new issue DD verified by:EC		
Checked & Approved By	: <u>SLU</u> 08.7.31						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D412-769-041 CHG 001 <i>N/A</i>		
2.0	D412769043	Aft Facing Seat Assembly, LH
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Aft Facing Seat Assembly, LH batch: <u>40917</u> <i>50</i>		
3.0	D412724041	Head Rest Assembly, Center
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Head Rest Assembly, Center batch: <u>42084</u> <i>54</i>		
4.0	D412724043	Head Rest Assembly, LH
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Head Rest Assembly, LH batch: <u>42087</u> <i>89124</i> <i>54</i>		
5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
Comment: INSPECT 100% KITS FOR COMPLETENESS <i>S 09 109/04</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT, LH

Job Number: 40809

Part Number: D412769041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Q

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-769-041

Location:

PPP Rev:

PPP 40809

8/9/24

SM

7.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/24 AF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 8/09/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011 Aft Facing Seat kit	60.0 lb 27.2 kg	0.0 in 0.0 m	0.00 in-lb 0.00 m-kg	87.0 in 2.21 m	5220 in-lb 60.11 m-kg
D412-769-041 Aft Facing Seat, LH (normal position)	30.0 lb 13.6 kg	-16.1 in -0.41 m	-483.0 in-lb -5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (normal position)	30.0 lb 13.6 kg	+16.1 in +0.41 m	+483.0 in-lb +5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (center position)	30.0 lb 13.6 kg	-1.1 in -0.03 m	-33.0 in-lb -0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (center position)	30.0 lb 13.6 kg	+1.1 in +0.03 m	+33.0 in-lb +0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (right Position)	30.0 lb 13.6 kg	+13.9 in +0.35 m	+417.0 in-lb +4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (left Position)	30.0 lb 13.6 kg	-13.9 in -0.35 m	-417.0 in-lb -4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg

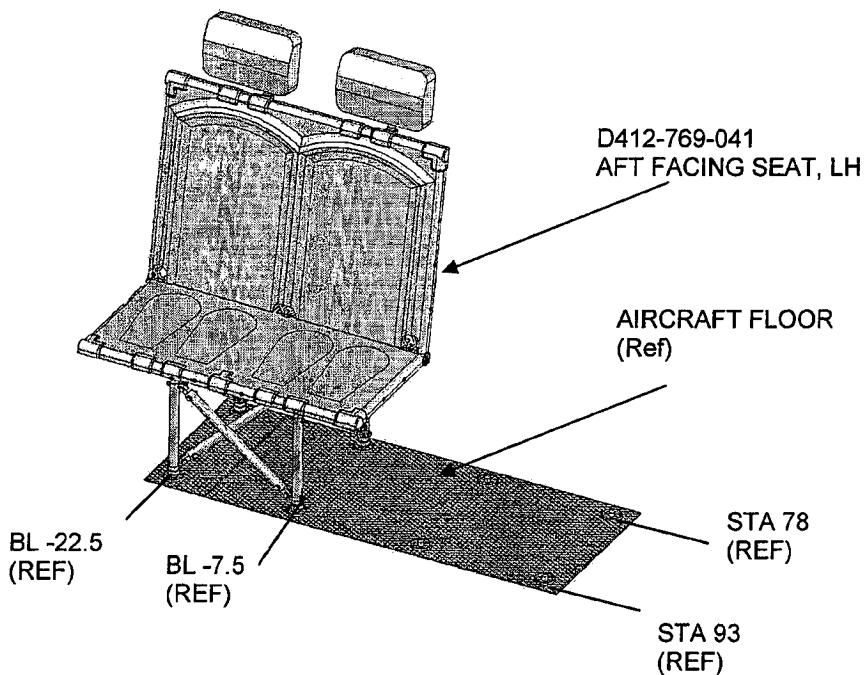
5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
1			D412-769-043	AFT FACING SEAT ASSEMBLY, LH
	1		D412-769-044	AFT FACING SEAT ASSEMBLY, RH
1	1		D412-724-041	HEAD REST ASSEMBLY, CENTER
1			D412-724-043	HEAD REST ASSEMBLY, LH
	1		D412-724-044	HEAD REST ASSEMBLY, RH

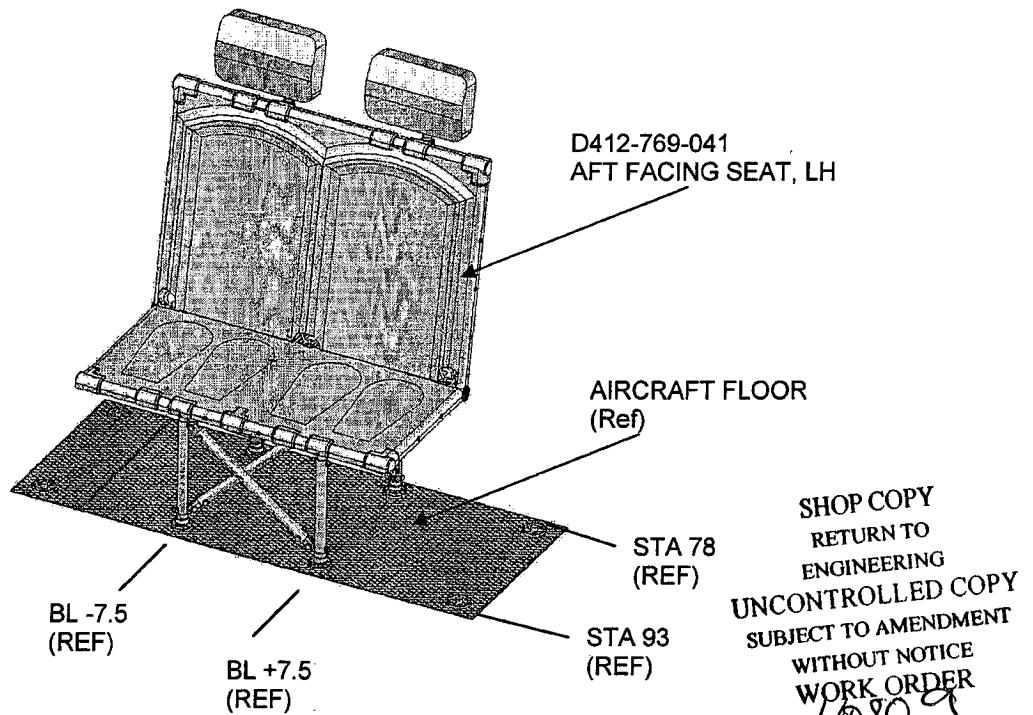
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Revision: B
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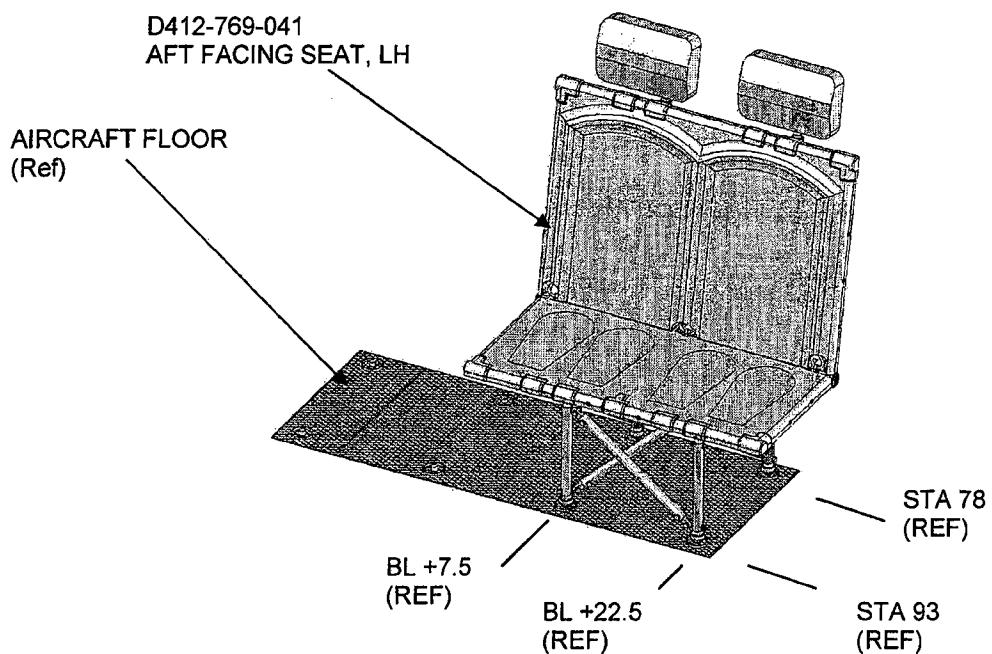
**FIGURE 3: D412-769-041 Aft Facing Seat, LH
(LH Installation)**



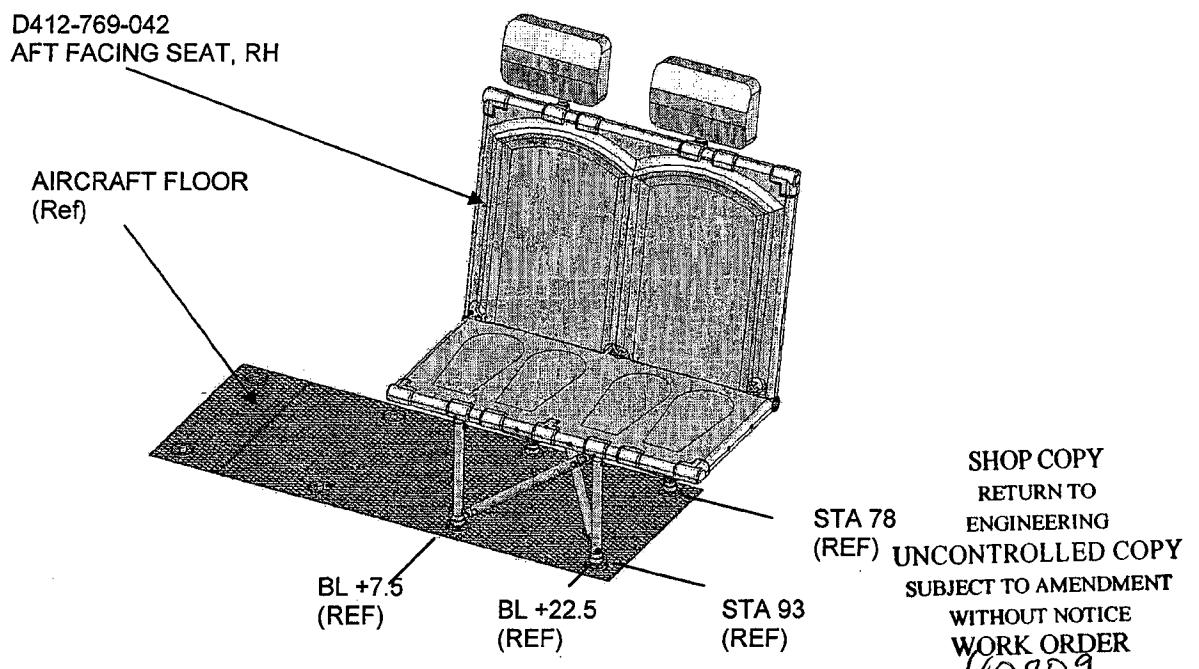
**FIGURE 4: D412-769-041 Aft Facing Seat, LH
(Center Installation)**

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**FIGURE 5: D412-769-041 Aft Facing Seat, LH
(RH Installation)**

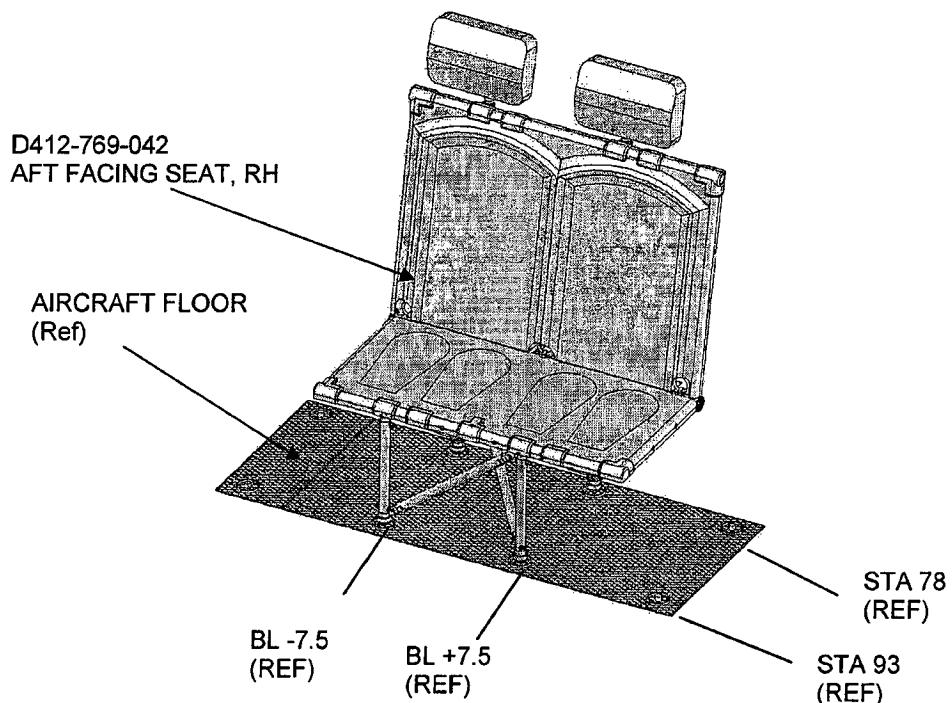


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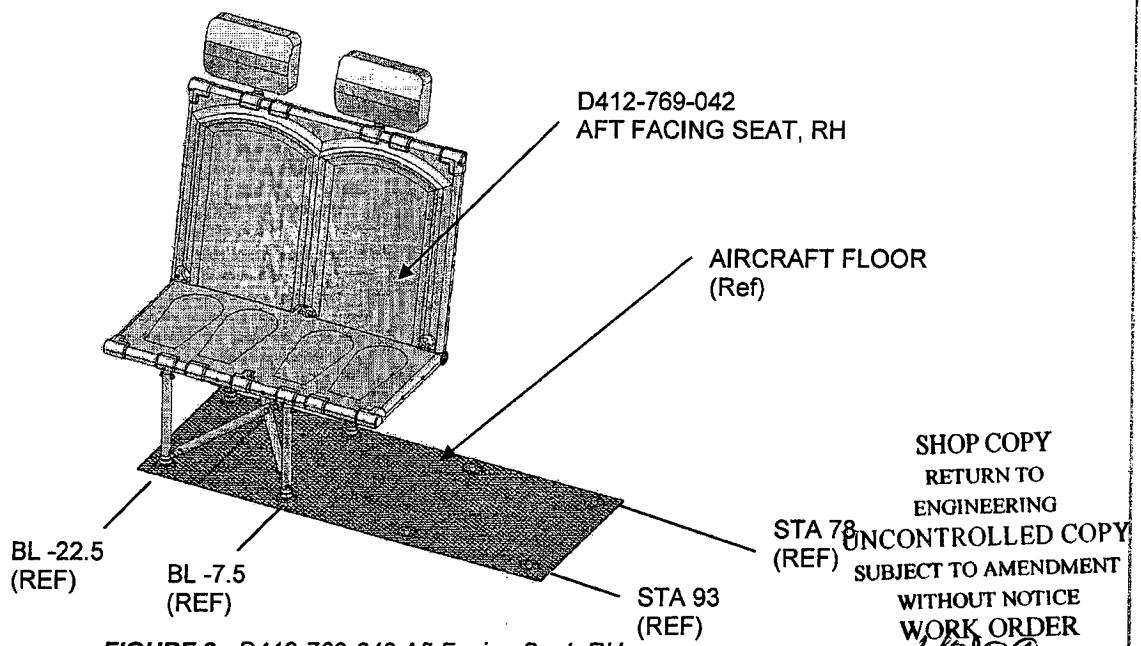
**FIGURE 6: D412-769-042 Aft Facing Seat, RH
(RH Installation)**

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**FIGURE 7: D412-769-042 Aft Facing Seat, RH
(Center Installation)**



**FIGURE 8: D412-769-042 Aft Facing Seat, RH
(LH Installation)**

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